

Date: Thursday, 5/3/2007 11:38:42 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32201
Estimate Number : 11162
P.O. Number : **NIA**
This Issue : 5/3/2007 S.O. No. : **NIA**
Prsht Rev. : NC
First Issue : **NIA** Type : MACHINED PARTS
Previous Run : 29566
Written By : _____
Checked & Approved By : _____
Comment : Est A 04.09.02 New issue K/J

| | | | |
|------------------|---------------|------|----------|
| Drawing Name | : BRACKET | | |
| Part Number | : D32641 | | |
| Drawing Number | : D3264 REV A | | |
| Project Number | : N/A | | |
| Drawing Revision | : A | | |
| Material | : NIA | | |
| Due Date | : 5/10/2007 | Qty: | Um: Each |
| | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|----|--------------------|--------------------------|
| 10 | M6061T6B1250X04500 | 6061-T6 Bar 1.25" X 4.5" |
|----|--------------------|--------------------------|



Comment: Qty.: 0.5097 f(s)/Unit Total : 3.0580 f(s)
Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick
(M6061T6B1.250x04.500)
Identify for D3264-1
Batch: M17655 x 2 M185531 x 3

20 BAND SAW BAND SAW



Comment: BAND SAW
Cut blanks: 4.500" x 1.250" x 5.700" long Bar

| | | |
|----|-------|--------------------------------|
| 30 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA447 and Dwg D3264
Identify as D3264-1
Deburr

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/16/12
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:38:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32201

Part Number: D32641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ML

07-10-11

(12)

7.0

POWDER COATING

POWDER COATING



M105068



(12x)

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

M-L

07/10/11

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ML



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-10-11

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: *57158*

07/10/12

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

07/10/12

Job Completion



07-10-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No. DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 32201 |
| Description: Bracket | | Part Number: | D3264-1 |
| Inspection Dwg: D3264 Rev: A | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 0.687 | +/-0.010 | 0.689 | — | | | |
| 0.063 | +/-0.010 | 0.063 | — | | | |
| 0.125 | +/-0.010 | 0.117 | — | | | |
| 0.875 | +/-0.010 | 0.868 | — | | | |
| 0.062 | +/-0.010 | 0.063 | — | | | |
| R0.03 | +/-0.030 | R0.030 | — | | | |
| R0.13 | +/-0.030 | R0.125 | — | | | |
| 1.00 | +/-0.030 | 1.001 | — | | | |
| 0.125 | +/-0.010 | 0.125 | — | | | |
| 0.600 | +/-0.010 | 0.599 | — | | | |
| 4.000 | +/-0.005 | 4.000 | — | | | |
| 0.750 | +/-0.010 | 0.751 | — | | | |
| Ø0.194 | +0.005/-0.000 | Ø0.195 | — | | | |
| 5.50 | +/-0.030 | 5.506 | — | | | |
| 0.125 | +/-0.010 | 0.125 | — | | | |
| 0.063 | +/-0.010 | 0.063 | — | | | |
| R0.25 | +/-0.030 | R0.250 | — | | | |
| 4.27 | +/-0.030 | 4.276 | — | | | |
| R0.30 | +/-0.030 | R0.30 | — | | | |

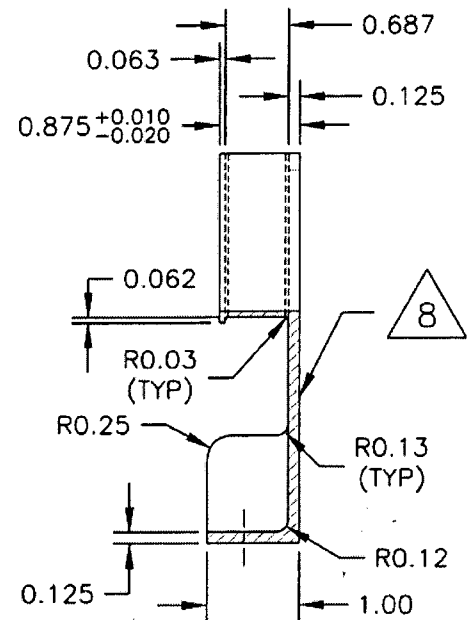
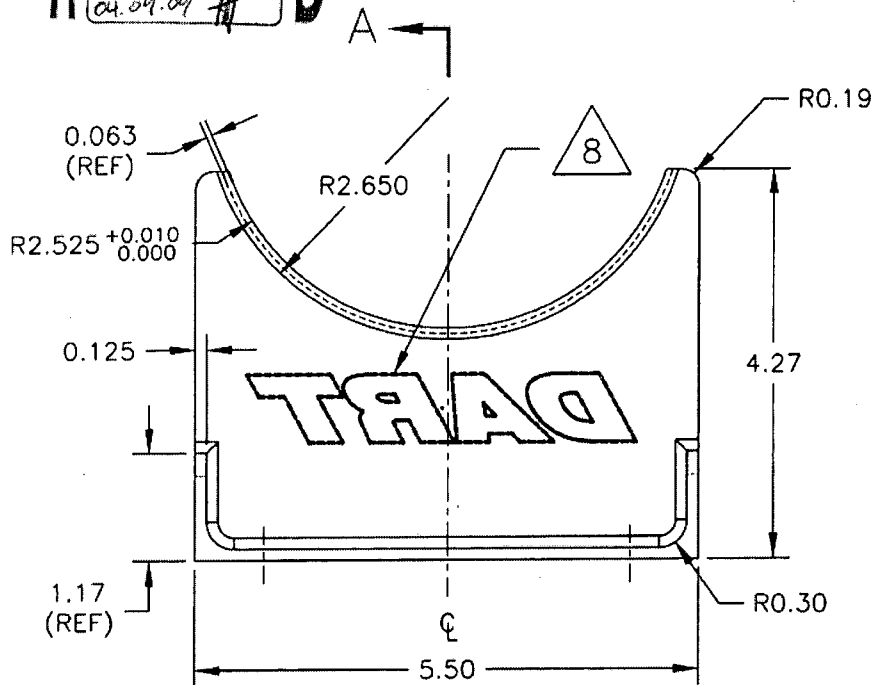
| | | | | | |
|---------------------|--------------------|--------------------|----------|----------------------------|-----|
| Measured by: | <i>[Signature]</i> | Audited by: | J.L | Prototype Approval: | N/A |
| Date: | 07/10/09 | Date: | 07/10/09 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------------------------|------------|--------------------|
| A | 04.09.03 | New Issue | KJ/JLM | |
| B | 05.04.26 | Ø0.194 was Ø0.208; dimensions removed | KJ/JLM | <i>[Signature]</i> |

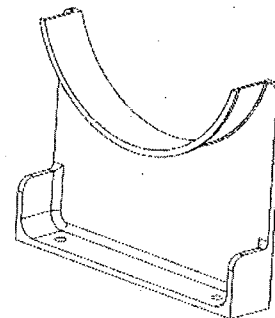
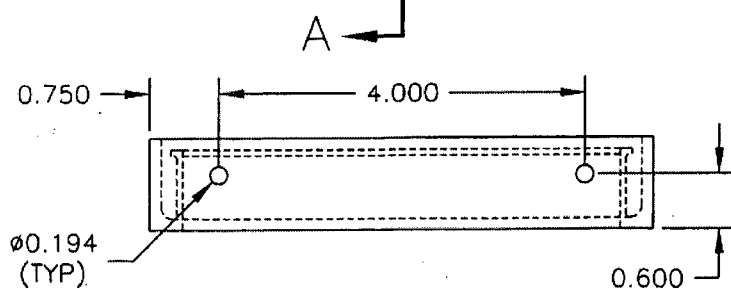


| | | | |
|------------------|----------------|---|------------------------|
| DESIGN RT | DRAWN BY RT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D3264 | REV. A SHEET 1 OF 1 |
| DATE 04.04.20 | | TITLE BRACKET | SCALE 1:2 |
| A | 04.04.20 | NEW ISSUE | |

RELEASED
04.09.09 H



SECTION A-A



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M5061T68)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3220

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